

Work Order ID 143536

Monday, March 21, 2016 9:49:35 AM

143536

Page 1

Item ID: D3670-4-200 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 3/21/2016 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 3/23/2016 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 160321 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3670	Rev A								
100	Hardinge CNC LATHE SMALL	0.00							DAS 14 9-39
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA711 & DWG D3670FOLIO REV: <u>NA</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED								16/03/22
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 14 9-39
110									
QC	Memo	0.00							
Quality Control									16/03/22
120	QC8- Inspect parts - second check	0.00							DAS 44 9-89
120									
QC	Memo	0.00							
Quality Control									16/03/23

101

Work Order ID 143536

Monday, March 21, 2016 9:49:35 AM

143536

Page 2

Item ID: D3670-4-200

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 3/21/2016 Start Qty: 100.00

100

Cust Item ID:

Required Date: 3/23/2016 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL*** LOCATION: LG001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SH 20160328

Picklist Print

Page 1

Monday, March 21, 2016 9:49:33 AM

Work Order ID: 143536

143536

Parent Item: D3670-4-200

D3670-4-200

Parent Item Name: Bushing

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 100.00

Required Qty: 100.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased		No			f	186.2500		36.01801			

M6061T6T0 3125W 058

**

ALUM TUBE .3125 x .058w

Location

Loc Qty

Loc Code

MAT013

186.25

→ m133509

54.25

m133914

24

m134504

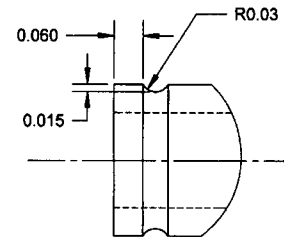
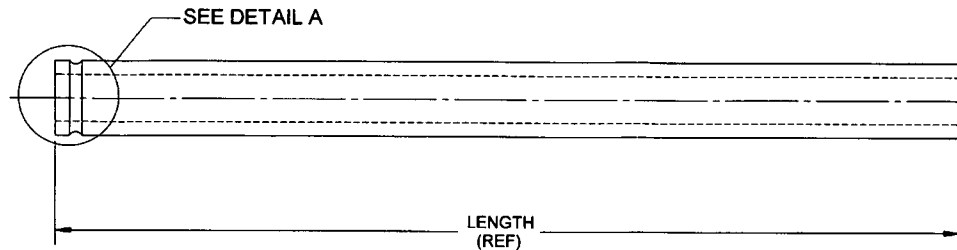
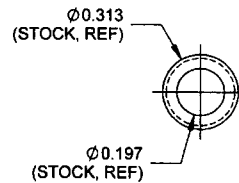
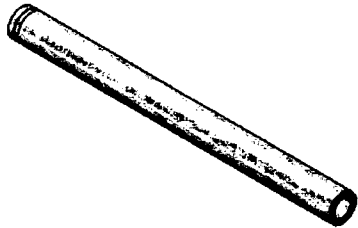
108

41.5

DAS
14
9-89

16/03/22

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143536 MJS
16-03-29

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

A	NEW ISSUE	DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DF		
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	ED	D3670	SHEET 1 OF 1
APPROVED	MH	TITLE	SCALE
DE APPR.	TH	SPACER	2:1
DATE	07.10.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	